



## INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification <sup>6</sup> :  C02F 3/12, 3/20, 3/30		A1	(11) International Publication Number: WO 97/00832  (43) International Publication Date: 9 January 1997 (09.01.97)						
<p>(21) International Application Number: PCT/AU96/00379</p> <p>(22) International Filing Date: 21 June 1996 (21.06.96)</p> <p>(30) Priority Data:</p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%;">PN 3711</td> <td style="width: 33%;">22 June 1995 (22.06.95)</td> <td style="width: 33%;">AU</td> </tr> <tr> <td>PN 6207</td> <td>26 October 1995 (26.10.95)</td> <td>AU</td> </tr> </table> <p>(71) Applicant (<i>for all designated States except US</i>): BISASCO PTY. LIMITED [AU/AU]; 35 Silsoe Street, Hamilton South, NSW 2303 (AU).</p> <p>(72) Inventor; and</p> <p>(75) Inventor/Applicant (<i>for US only</i>): GORONSZY, Mervyn, Charles [AU/US]; 24751 Greentree Lane, Lake Forest, CA 92630 (US).</p> <p>(74) Agent: McCORMACK, John, David; Griffith Hack &amp; Co., 509 St Kilda Road, Melbourne, VIC 3004 (AU).</p>		PN 3711	22 June 1995 (22.06.95)	AU	PN 6207	26 October 1995 (26.10.95)	AU	<p>(81) Designated States: AL, AM, AT, AU, AZ, BB, BG, BR, BY, CA, CH, CN, CZ, DE, DK, EE, ES, FI, GB, GE, HU, IL, IS, JP, KE, KG, KP, KR, KZ, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, TJ, TM, TR, TT, UA, UG, US, UZ, VN, ARIPO patent (KE, LS, MW, SD, SZ, UG), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG).</p> <p><b>Published</b></p> <p><i>With international search report. Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments.</i></p>	
PN 3711	22 June 1995 (22.06.95)	AU							
PN 6207	26 October 1995 (26.10.95)	AU							
<p>(54) Title: CONTROLLING WASTEWATER TREATMENT BY MONITORING OXYGEN UTILISATION RATES</p>									
<p>(57) Abstract</p> <p>A method and apparatus for treating waste material to remove selected components from the waste is described using a reactor or a series of reactors in fluid communication with each other for receiving the waste to be treated as influent. The influent forms a biomass including the waste and microorganisms and is treated by controlling the metabolic activity of the microorganisms by monitoring the oxygen utilisation rate or the potential oxygen utilisation rate of the biomass so as to determine the required amount of oxygen to be supplied to the biomass and to determine the period of aeration of the biomass in order to maintain a predetermined oxygen utilisation rate or value so as to remove the selected components of the waste. The preferred selected components to be removed are nitrogenous, carbonaceous and/or biological phosphorus containing materials or derivatives.</p>									

**FOR THE PURPOSES OF INFORMATION ONLY**

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AM	Armenia	GB	United Kingdom	MW	Malawi
AT	Austria	GE	Georgia	MX	Mexico
AU	Australia	GN	Guinea	NE	Niger
BB	Burbados	GR	Greece	NL	Netherlands
BE	Belgium	HU	Hungary	NO	Norway
BF	Burkina Faso	IE	Ireland	NZ	New Zealand
BG	Bulgaria	IT	Italy	PL	Poland
BJ	Benin	JP	Japan	PT	Portugal
BR	Brazil	KE	Kenya	RO	Romania
BY	Belarus	KG	Kyrgyzstan	RU	Russian Federation
CA	Canada	KP	Democratic People's Republic of Korea	SD	Sudan
CF	Central African Republic	KR	Republic of Korea	SE	Sweden
CG	Congo	KZ	Kazakhstan	SG	Singapore
CH	Switzerland	LI	Liechtenstein	SI	Slovenia
CI	Côte d'Ivoire	LK	Sri Lanka	SK	Slovakia
CM	Cameroon	LR	Liberia	SN	Senegal
CN	China	LT	Lithuania	SZ	Swaziland
CS	Czechoslovakia	LU	Luxembourg	TD	Chad
CZ	Czech Republic	LV	Latvia	TG	Togo
DE	Germany	MC	Monaco	TJ	Tajikistan
DK	Denmark	MD	Republic of Moldova	TT	Trinidad and Tobago
EE	Estonia	MG	Madagascar	UA	Ukraine
ES	Spain	ML	Mali	UG	Uganda
FI	Finland	MN	Mongolia	US	United States of America
FR	France	MR	Mauritania	UZ	Uzbekistan
GA	Gabon			VN	Viet Nam

## CONTROLLING WASTEWATER TREATMENT BY MONITORING OXYGEN UTILISATION RATES

This invention relates to improvements in wastewater treatment generally and in particular to wastewater treatment methodology using micro-organisms and means of controlling the metabolic activity of those micro-organisms in a variable volume activated sludge reactor which is intermittently, aerated and decanted. More particularly, the present invention relates to methods and apparatus for controlling the metabolic activity of dispersed growth micro-organisms through the regulated supply of oxygen relative to in basin biomass oxygen uptake rate measurements, to achieve the beneficial result of carbon or carbonaceous material removal, as measured by COD, BOD, TOC; nitrogen removal as measured by TKN, NH<sub>3</sub>-N, NO<sub>2</sub>-N, NO<sub>3</sub>-N; and phosphorous removal, as measured by PO<sub>4</sub>, from a wastewater. The present invention finds particular application in treating domestic wastewater, industrial wastewater or a mixture thereof. The invention particularly relates to maximising the rate of removal of biologically degradable materials in a wastewater by micro-organisms by optimising the metabolic activity of the micro-organisms that are used in a single sludge reaction procedure. In so doing it is recognised that there are at least four major species or families of micro-organisms in the overall biological consortia that need to be maintained. Those micro-organisms that are generally responsible for the net removal of carbohydrate type compounds, those micro-organisms that generally oxidise nitrogen compounds to nitrate nitrogen, those micro-organisms that generally denitrify nitrate to nitrogen gas and those micro-organisms that generally participate in enhanced biological phosphorus and in the overall hydrolysis of degradable volatile solids to soluble

- 2 -

degradable substrate. Up to 20000 individual species of micro-organisms can be contained in the overall consortia constituting the biomass.

5 Although the present invention will be described with reference to the treatment of industrial wastewater and domestic wastewater and to the methodology of such treatments, it will be appreciated by one skilled in the art that the invention is not limited to such applications and may be used to treat any type of biologically  
10 degradable wastewater or otherwise, and any type of waste including water or waste having the specific impurities or contaminants as discussed herein.

15 Conventional activated sludge processing requires detailed monitoring information on which to base process control decisions to meet treatment objectives. These analyses, which are well known to practitioners of the art, typically include BOD (total), COD (total), BOD (soluble), COD (soluble), TKN, ORG-N, NO<sub>x</sub>-N, ortho Phosphate, total  
20 Phosphate, pH, Alkalinity for both influent and effluent streams. In basin measurements include, Dissolved Oxygen Concentration, Mixed Liquor Suspended Solids Concentration, Mixed Liquor Volatile Suspended Solids Concentration, Sludge Settled Volume, Biomass Degradable Fraction (through aerobic digestion of the biomass for 28 days). Simple  
25 parameters, incorporating the Potential Oxygen Utilisation Rate (POUR) and its actual utilisation rate are used for the automatic control and operation of a single activated sludge variable volume reactor in order to achieve a very high degree of carbon, nitrogen, phosphorus removal without  
30 sludge bulking.

The present invention relates to activated sludge wastewater treatment, the principal reactor of which is configured for complete-mix operation. While variable volume intermittently aerated and decanted fed-batch

- 3 -

- operation can be used as the preferred embodiment, the technique also applies to constant volume continuously aerated complete-mix operation. The keywords are fed-batch, intermittently aerated, complete-mix, reactor basin.
- 5 In this invention there maybe a series of activated sludge reactors all connected by conduit pipe or other means, with or without means for flow interruption between the said reactors. The last reactor in each series of reactors is termed the principal reactor from which the biologically treated effluent is directed. It will be apparent to those skilled in the art, that the reactor may be formed as a slope walled lagoon structure, with earthen, concrete stabilised, membrane lined or concrete retaining walls, or as a conventional reinforced concrete walled vessel or as a structural steel vessel. While some shapes, and dimensioning ratios of the basins may be preferred it is important to state that any geometrically shaped vessel (square, rectangular, circular) can be operated in accordance with this invention specification.
- 10
- 15
- 20 It is well known by those experienced in the art that a number of reaction conditions need to be satisfied in order to achieve biological nitrification - denitrification and enhanced biological phosphorus removal. In particular the nitrification reaction requires an adequate supply of
- 25 inorganic carbon. The removal of phosphorus by biological means requires selectivity reaction circumstances to cause the necessary micro-organisms to proliferate. Among those requirements is a substrate preferably containing volatile fatty acids and more commonly referred to as readily degradable soluble substrate. Additionally required are reaction conditions that cycle between the so called description of oxic and anaerobic. It is necessary to be more definitive when using these terms as there are degrees of anaerobicity which trigger certain biological reactions.
- 30
- 35 An absence of oxygen and nitrite - nitrate is in current terminology not sufficient to describe "anaerobic" to the

- 4 -

extent that biological phosphorus removal will take place. Anaerobic reaction conditions require a more exacting definition when applied to phased activated sludge processing whereby oxic, anoxic and anaerobic reaction 5 conditions can be induced on a single sludge culture by relatively simple manipulation of fill and aeration sequencing. Selectivity pressures are dominated by exposure of the culture to high acetate - substrate loading pressures under sequenced anaerobic, anoxic and oxic 10 reaction conditions. An absence of nitrate and dissolved oxygen concentration is not sufficient to define anaerobic conditions which will cause the relevant micro-organisms species to release its content of Poly P. According to conventional knowledge it is usual to describe appropriate 15 reaction conditions in terms of a bulk liquid oxidation reduction potential (a value of EMF referenced to a standard electrode measurement of hydrogen or silver chloride). Hence this value needs to be sufficiently negative (-150mV, Hydrogen electrode reference) to ensure a 20 degree of definable anaerobicity to ensure the phosphate release mechanism. It has been found that the ORP depletion rate from positive (oxidizing) conditions to negative (reducing) conditions is functional on the metabolic activity of the biomass at the switching 25 oxidation reduction potential. The same metabolic activity is a function of the amount of residual intracellular storage compounds maintained in the culture. Using this description, a biomass having a high value of oxygen uptake rate in an oxidation environment will rapidly approach more 30 negative ORP values when the oxidizing reactant (oxygen) is removed. A biomass having a lower value of oxygen uptake rate will consequently deplete its ORP at a slower rate. Biological phosphorus release occurs at a value some 250 mv 35 more positive than the values that equate to the reduction of sulfate to sulfide. In the practice of the art, using other conventional constant volume processing, it has been necessary to define hydraulic retention time criteria as a

- 5 -

means of ensuring appropriate reaction conditions. Through research and trial and error, a range of parameters has been found, relating to process and simply described in terms of the actual oxygen uptake rate of the single sludge biomass that can be used to specify the reaction conditions that ensure a reliable and continued desirable process result. The application of these control parameters to the operation of the preferred embodiment provides an overall process that is less expensive than the generally accepted conventional methodology and one which is much less complex to operate. The principal parameter relates to an overall activity level of the biomass as measured by its oxygen utilisation rate (OUR) and its potential oxygen utilisation rate (POUR). Process control using these parameters enables the use of set point values which obtain the reliable removal of pollutants and nutrients and at the same time produce a biomass which has excellent solids - liquid separation properties.

Therefore, it is an aim of the present invention to provide a method and apparatus for treatment of wastes which at least alleviates one or more of the problems of existing methods and apparatus by more closely monitoring process conditions and parameters relating to the activity of the biomass, such as for example oxygen utilisation rates including potential oxygen utilisation rates.

According to the present invention there is provided a method of treating waste by controlling metabolic activity of micro-organisms of a biomass containing the waste so as to remove selected components of the waste prior to disposal of treated waste, characterised in that the method comprises monitoring at least one oxygen utilisation rate of the biomass in order to determine a requisite amount of oxygen to be supplied to the biomass and monitoring a period of aeration of the biomass by the oxygen so as to maintain a predetermined oxygen utilisation rate or value

- 6 -

to achieve removal of the components.

One aspect of the present invention relates to the sizing of the activated sludge reactor(s), their mode of operation and the automatic optimisation of the amount of oxygen supplied to the reactor(s) in terms of rate and time of application by sensing the metabolic activity of the biomass in the principal reactor. This metabolic activity is sensed as the actual oxygen utilisation rate of the biomass in the principal reactor near to the end or at the end of an air-on sequence. Upon interruption of the supply of air to the principal reactor, the contents therein remain in motion for up to ten minutes, the natural mixing motion increasingly decreases with time. Values of dissolved oxygen concentration are sensed and monitored at intervals of ten or twenty seconds. A minimum of ten points are taken and mathematically treated to provide a slope of best fit which best describes the initial dissolved oxygen depletion rate and hence a nominal actual oxygen utilisation rate. These data are trend plotted with cycle volume, the volumetric load, pertaining to the activity measurement plus the maximum dissolved oxygen concentration sensed during the cycle. The sensed dissolved oxygen concentration and blower speed profile is also recorded. The invention relates to the maintenance of a biomass (mixed culture of micro-organisms), through optimal oxygen input, having a selectable optimal biological activity as measured by its oxygen utilisation rate, volatile suspended solids fraction and degradable volatile suspended solids fraction as later defined. The dissolved oxygen sensor measures the in-situ biomass oxygen utilisation rate for use in controlling and regulating the input of oxygen from the air input device pump or compressor. As described with reference to the preferred embodiments, reaction conditions in this principal reactor variously sequence from air-on to air-off. An air-on sequence will typically be continuous and occurs while

- 7 -

influent wastewater is introduced into the basin(s) then stops during which time the biomass in the principal treatment reactor settles after which supernatant clear liquid is removed from the principal process reactor. The 5 invention operates similarly with non-continuous air on sequencing. When the effluent removal sequence is completed air and untreated wastewater is again introduced into the principal process reactor until the air sequence is again stopped. A total cycle of operation can typically be four 10 hours, an aeration sequence will typically be two hours; other time combinations can be used. To those skilled in the art it can be easily seen that other time increments may be used. Two measurements are made. The rate of 15 depletion of dissolved oxygen during the initial minutes after the cessation of aeration. Other intermediate rates associated with multiple aeration sequencing can also be read. A second rate is measured when the air is again turned on during which time a maximum flow rate of air is 20 introduced into the reactor or a section of the reactor for a set time (this is a variable which needs to be set for each plant and be subject of relatively infrequent adjustment through a check calibration procedure. The rate of change of dissolved oxygen  $(dO_2)/dt$  increase and 25 depletion, and the manner in which the biomass settles  $d(MLSS)/dt$  are related where  $O_2$  refers to concentration of dissolved oxygen and (MLSS) refers to simple concentration of activated sludge. Both vary with time when the introduction of air to the basin is stopped. Similarly there is a time variation of both parameters during the 30 initial period of an aeration sequence. In the preferred embodiment the principle reactor of the system is configured with diffuser grids and feed lines to provide more than one effective mixed reaction zone upon introduction of air. A minimum of one section of the 35 principal reactor will typically be aerated at the start of an aeration sequence. Biomass from this initial aerated mixed zone is used to determine the rate of change of

- 8 -

oxygen increase at the start of an aeration sequence. In the preferred embodiment it is possible to time select the various grid zones for aeration. In those embodiments that have a single grid assembly, the same results will be obtained through aeration of the total principal reactor volume.

A part of the invention lies in the in-basin measurement of oxygen utilisation rate in order to provide the requisite oxygen in terms of rate of supply and period of aeration, to maintain a set point oxygen utilisation rate. This in turn sets the reaction conditions for the processing of wastewater using fed-batch single sludge single reactor technology. Measurement and control is but one part of the invention. The reactor basin processing, as described by the preferred embodiment, is closely associated with the measurement aspect. Both are cognate in the present invention. It will be understood by those experienced in the art that aeration of the principal reactor for too long, in successive sequences, will quickly lead to a loss of metabolic activity of the biomass therein and a subsequent inability of that biomass to properly denitrify and to take part in the removal of phosphorus by biological mass. Over aeration of the biomass will also lead to a reduced floc aggregation and hence an undesirable increase in effluent suspended solids concentration. Continued operation outside of the desired sludge age envelope will lead to a similar consequence. Biomass oxygen utilisation rate measurement is used to fix the envelope of operating sludge age.

The present invention will now be described by way of example with reference to the accompanying drawings in which:

Figure 1 is a schematic view of one form of the reactor of the present invention having a single reactor divided into two compartments;

- 9 -

Figure 2 is a schematic view of another form of the reactor of the present invention being a single basin configuration having a main reactor and separate auxiliary reactors;

5       Figure 3 is a schematic view of one form of an intra floc anoxic-denitrification model used in the present invention;

Figure 4 is a plot of biorate feed-starve set point operation;

10      Figure 5 is a schematic diagram showing definitive conditions of oxic, anoxic and anaerobic reaction conditions expressed in terms of bulk phase measured oxidation reduction potential;

15      Figures 6(a) to 6(g) are schematic views of alternative forms of the reactor showing different configurations for feed inputs and effluent outlets, including multi-split inputs and outlets.

20      While it will be realised by those experienced in the art, that the reaction embodiment can take a number of forms, a simple embodiment for the purposes of instruction will now be described.

In Figure 1 is shown schematically one form of a single basin reactor of the present invention. The boundary of the reactor basin shown in Figure 1 is shown in elevation and is depicted as (1) being of solid construction and designed to contain water. A minimum of two reactor zones, shown as (3) and (4) caused by a sub compartment, partial wall, baffle wall or the like (shown as (2)), is depicted. The reactor zones are in fluid communication by pipe or other conduit or by a section of open area formed by the partial baffle wall. Means for diffusing air for the reactive oxygen component, preferably by a grid of membrane diffusers, is shown as (5) receiving a flow of compressed air from a mechanical engine shown as (6). A means for transferring the contents of (4), the principal reactor,

- 10 -

using a regulating transfer pump to come in contact with the influent flow (designated (11)) and for its admixture and reaction in (3) is shown. Two important levels are shown in the reactor basin, that of (8), the designated bottom water level and that of (9), the designated top water level. In this embodiment a sequence of aeration takes place while flows designated (10) and (11) take place, i.e. filling from bottom water levels (8) to top water level (9). When this sequence is complete, the means of aeration are interrupted to stop the mixing and oxygen transfer procedure thus allowing the mixed solids to settle and separate to form an overlaying supernatant clear layer of liquid on top of a layer of settled solids. At an appropriate time the decanter (9) is caused to function and to remove the volumetric depth between (8) and (9), after which its functionality ceases until the end of the next cycle. In this embodiment inflow (11) may be continuous or intermittent; outflow through the operation of the decanter (9) is necessarily discontinuous relative to the total time span of the cycle that permits the operation of inflow and aeration, settle and decant. The placement of a dissolved oxygen sensor (12) either within the principal reactor (4) or within the pumped line feeding biomass from the principal reactor for admixture of influent (11) within the initial reaction zone (3), is marked 14. An instrument that can be used for monitoring the in-basin concentration of the biomass (mixed liquor suspended solids) shown as (13) may be used in the preferred embodiment. A sludge blanket interface detector (15) is also useful for automatic sludge wasting operation from the preferred embodiment. Two floor mounted diffuser grid assemblies are shown; (16) and (17) schematically show means for selectively using a grid assembly which is constituted by more than two downcomer - valve attachments. It will be seen by those that are experienced in the art that a principal reactor basin may have many more than two downcomer valve attachments, depending upon the total area

- 11 -

of the reactor basin and the effective area of influence of the means for diffusion mixing and oxygen transfer. Reactor embodiments provide for selective and sequenced area aeration or for total area aeration.

5      The embodiment of the reactor(s) of the present invention shown in Figure 2 has similar components to the reactor of Figure 1 and accordingly the same reference numerals are used to identify similar features of the reactor(s).

10     The present invention relates to wastewater treatment methodology and means of controlling the overall metabolic activity of dispersed growth micro-organisms within a single sludge mass to achieve the beneficial result of reliable simultaneous carbonaceous removal, as measured by COD, BOD, TOC, nitrogen removal, as measured by TKN, NH<sub>3</sub>-N, NO<sub>2</sub>-N, NO<sub>3</sub>-N, and phosphorus removal, as measured by PO<sub>4</sub>, from a wastewater and within the time frame of a repetitive cycling of process events. The invention relates to means of measuring in-basin oxygen utilisation rate and manipulating aeration input to maintain a set point regime of reaction conditions that will permit single sludge single basin treatment for carbon removal and/or nitrogen removal and/or enhanced biological phosphorus removal. These reaction conditions are dependent upon a set point oxygen utilisation rate as it determines the viability of the microbial population at the set operating sludge age and is deterministic on the net settling properties of the single sludge. Wastewater may be essentially domestic or industrial or a mixture of both types.

25     Industrial wastewater is described as a discrete classification to differentiate from total household wastewaters which essentially comprise human wastes (faeces, urine), body washing wastewater, clothes washing wastewater and food preparation wastewater. Industrial wastewaters are essentially those wastewaters that are

- 12 -

generated in the manufacture of products and in particular  
are wastewaters that are biodegradable. State-of-the-art  
technologies using dispersed growth micro-biological  
reactions have been well described in the literature, for  
5 example:

- \* Quirk T., Eckenfelder W.W., and Goronszy M. C.,  
"Activated Sludge; State-of-the-Art". Critical  
Reviews in Environmental Control, CRC Press Vol.  
15, Issue 2, 1985.
  - 10 \* Eckenfelder W. Wesley, Jr. "Industrial Wastewater  
Treatment" McGraw Hill, 1991.
  - \* Eckenfelder W. Wesley, Jr. "Principles of Water  
Quality Management" C.B.I. Publishing Company,  
Inc., 1980.
- 15 Without limiting the coverage of the invention, reference  
is made to fractional components of a wastewater; the  
relative fractions may be different in domestic and  
industrial wastewaters. It is important to recognise that  
those fractions exist and their relative magnitude can  
20 impact upon the methodology of using the invention and the  
process configuration in which that invention is embodied.
- It is important to recognise that wastewaters typically  
comprise soluble and insoluble components which include  
readily degradable soluble organics, degradable soluble  
25 organics that are not as rapidly degradable, non degradable  
soluble organics, readily hydrolysable and degradable  
particulate substrates, slowly degradable particulate and  
non degradable particulate substrates. These substrates,  
their relative concentrations and their relative  
30 concentrations to other components such as TKN, NH<sub>3</sub>-N, NO<sub>2</sub>-  
N, total P and ortho P may have a large influence on the  
rate and generation of certain dispersed growth micro-  
organism species.

- 13 -

5

\* Goronszy M.C. and Eckefelder, W.W., "The rate of  
the degradation of primary solids in activated  
sludge plants" Proceedings Water Pollution  
Control Federation Conference, Toronto, Canada.  
October 1991.

10

Dispersed growth wastewater treatment methodology typically involves oxic, anoxic and anaerobic reaction environments and mechanisms through which energy transformations take place involving electron acceptors to generate a net reduction in concentration of organic compounds as measured by BOD, COD, TOC and nitrogen and phosphorus (Figure 5).

15

These regimes of processing can be generally described in part through the concentration of dissolved oxygen, nitrite and nitrate nitrogen, sulphate, phosphate and in part through the scale of oxidation reduction potential (ORP)

20

relative to the standard hydrogen electrode. Positive values of ORP typically relate to oxidative conditions while negative values of ORP typically relate to reducing conditions. There is no defined relationship between ORP and dissolved oxygen concentration on the positive scale,

25

although the input of oxygen as a chemical source of oxygen will cause a response in ORP to be less negative or more positive. Temperature can influence the relative value of ORP as can the presence and relative density of micro-

30

organism species. Essentially the removal of carbon compounds and TKN compounds requires aerobic conditions, the removal of NO<sub>3</sub>-N, and NO<sub>2</sub>-N requires anoxic to anaerobic conditions and the removal of P requires oxic-anoxic and anaerobic conditions with cyclic exposure of the biomass, or specified fractions of the biomass in the aeration basin, to achieve ORP reaction environments that vary between circa 50mV to -150mV (hydrogen electrode reference) to enable all of the processing reactions to take place. The understanding of the actual discrete

35

mechanisms, while being important to treatment results is

- 14 -

not important to the description of the preferred embodiment of the invention herein.

Suffice to say there are reaction regimes herein which provide an envelope of performance which is necessarily required to permit the single sludge removal of the herein beforementioned parameters. Typical domestic wastewaters are described by 24 hour flow weighted composite samples in which the measured parameters of total COD, TKN, Phosphorus are up to  $1000 \text{ mgL}^{-1}$ ,  $85 \text{ mgL}^{-1}$  and  $15 \text{ mgL}^{-1}$  etc.

10

TABLE 1

**Concentrations of Selected Constituents in  
Municipal Wastewaters**

	Constituent	Concentration (mg/L) related to wastewater strength		
		Strong	Medium	Weak
15	(a) BOD	400	220	110
	(b) COD	1000	500	250
	(c) SS	350	220	100
	(d) Nitrogen			
	Total	85	40	20
	Organic	35	15	8
20	Ammonia	50	25	12
	Nitrite	0	0	0
	Nitrate	0	0	0
	(e) Phosphorus			
	Total	15	8	4
	Organic	5	3	1
25	Inorganic	10	5	3
	(f) Alkalinity (as $\text{CaCO}_3$ )	150	100	50

- 15 -

The relative amounts of carbon, nitrogen and phosphorus indicated by literature values in Table 1 differ considerably from those required for normal biological growth as reflected in the proportion of carbon and 5 nitrogen given by the empirical analysis for cell material -  $C_5H_7NO_2$  - together with the fact that cells contain around 1 to 2% of phosphorus by mass. That is, carbon is present in short supply relative to nitrogen and phosphorus in raw sewage as illustrated by Table 2. This shortage is worse 10 for settled sewage and is further compounded by the fact that about 50% of the organic carbon is oxidised to  $CO_2$  in biological treatment.

15 The nitrogen and phosphorus in excess of biological requirements normally remain in the biological treatment plant effluent. The form in which these nutrients are present in the effluent may differ markedly from that in the influent.

Nitrogen is present in raw sewage mainly as organic 20 nitrogen and ammonia, much of which results from hydrolysis of urea, a major constituent of urine. In biological treatment some of this nitrogen is incorporated into new cell growth and is removed as biological sludge while most of the remaining nitrogen may be either in the form of ammonia or, depending upon conditions in the plant, as the oxidised form, nitrate, and to a lesser extent nitrite. Some organic nitrogen also remains in the effluent, mainly 25 in association with the effluent suspended solids.

- 16 -

TABLE 2

**Nutrient Imbalance in Municipal Wastewaters for  
Medium Strength Wastewater**

		Relative Nutrient Proportions		
		Carbon (mg/L)	Nitrogen (mg/L)	Phosphorus (mg/L)
5	Typical Biomass (C <sub>5</sub> H <sub>7</sub> NO <sub>2</sub> , & P = N/5)	60	14	2.8
10	Wastewater	BODS = 220 BOD <sub>ult</sub> = 323 C = 120	NH <sub>4</sub> -N = 25 Org.- N = 15 Total N = 40	10
15	Uptake in CELL GROWTH (Net Yield = 0.5) gcellC / GwasteC	60	14	2.8
20	Residual Effluent Concentration (mg/L)	-	26	7.2
	Overall Removal (96)	100%	35%	28%

Phosphorus is present in raw sewage in two major forms - organic and inorganic. There are in fact many forms of phosphorus compounds in raw wastewaters, either in solution

- 17 -

or in suspension. Inorganic dissolved forms consist mainly of orthophosphates and condensed phosphates while the dissolved organic forms are organic orthophosphates.

5 One of the specific mechanisms concerns reaction conditions which maximise the initial rate of removal and storage of the readily degradable soluble fraction of the influent wastewater flow entering the treatment plant. The treatment plant is herein described as means to receive said wastewater, means of contacting the influent flow of wastewater with the manufactured active micro-organisms, means to contain said wastewater in contact with the degrading micro-organisms to effect the envelope of performance and means for separating the said treated wastewater from the degrading and remaining micro-  
10 organisms. The envelope of performance concerns the manufacture or presence of a sufficient concentration of active micro-organisms ( $X_0$ ) such that intimate contact of these micro-organisms with the influent wastewater readily degradable soluble substrate ( $S_0$ ) causes a rapid enzymatic reaction whereby the  $S_0$  is transferred into the bacterial culture with the subsequent generation of PHB, glycogen and/or other intermediate 'storage' compounds within the cell structure of the reactive micro-organisms with a  
15 subsequent generation of glycocalyx (a coagulating polysaccharide compound). The transfer of substrate from the liquid phase to the solid phase is energy demanding. Under measurable oxic reaction conditions there is a rapid increase in the rate of demand for using dissolved oxygen (its oxygen utilisation rate). The energy oxygen  
20 equivalence can easily be measured by introducing a mass of dissolved oxygen to the biomass, the rate of utilisation is measured through simple dissolved oxygen versus time measurements. As the relative magnitude of the ratio  $S_0$  to  $X_0$  increases, the peak oxygen utilisation rate increases  
25 until a maximum or plateau value is reached. This is the first reaction envelope which also specifies a mass and  
30  
35

- 18 -

rate of removal of readily degradable soluble substrates. The rate of utilisation of oxygen also parallels the rate of removal of liquid phase soluble substrate and this allows the energy inter-relationship to be formulated  
5 (Figure 3).

The measurement of degradation of a wastewater using an oxygen balance assumes that all oxygen consuming reactions involve a soluble substrate under biological growth reactions.

- 10 In a dispersed growth culture, new micro-organisms are formed as other viable cells are lost through endogenous metabolism, lysis and predation. The net active fraction of a bioculture is related to the limiting fraction of non-degradables, sludge age (MCRT) and the loss of cell  
15 viability. Reduction in the availability of food (the initial loading condition) or the over (extended) aeration of a culture having limited food availability will effectively cause a loss of microbial viability.
- 20 The transfer of dissolved oxygen to the liquid phase for use in meeting the oxygen demand of the combined wastewater and bioculture is very complex. The most important factors that need to be considered include, the water chemistry, the specific geometry and mechanism of the transfer device, basin geometry (width, length, side water depth), power  
25 input per unit volume of wetted basin, wetted depth to wetted area of basin, total dissolved solids, residual dissolved oxygen concentration, temperature, surface tension, mean diameter of air bubbles, retention time of air bubbles in liquid medium, oxygen demand of basin  
30 contents, air flow rate per oxygen transfer device, ratio of areas of air flow rate device to total basin floor area, area distribution of oxygen transfer devices, altitude, concentration of the bioculture, system sludge age, active fraction of the bioculture, mean particle size of the

- 19 -

bioculture, bulk removal rate of dissolved oxygen by the biomass (hereinafter referred to as BIORATE).

Oxygen and its rate of utilisation, for all of the reactions taking place involving the adsorption, absorption 5 of nutrients, their metabolism into biosolids and the subsequent degradation of biomass, is of prime importance. The provision of oxygen at an adequate rate is therefore the key element to the use of cyclic aerobic, facultative and anaerobic micro-biological treatment methodology for 10 the net rate of removal of nutrients by oxidative and reductive means, for the net rate of accumulation of biosolids and for the net removal of phosphates by biological means. The rate of supply of oxygen, its net residual concentration and the BIORATE, relative to the 15  $S_0/X_0$  distribution generally determines net growth factors for different groups of micro-organisms generally described as predominantly floc-forming or as filamentous forms. An overgrowth of filamentous forms is counterproductive to the treatment goals as this condition causes a disruption of 20 the processing time scale for solids - liquid separation. It is therefore mandatory that biological growth associated with predominantly floc-forming micro-organisms. The cognition of the preferred process embodiment and the means 25 for biomass process control based on oxygen utilisation rate set-points are directed to this objective.

The removal of nutrients by each of the mechanisms of adsorption, biosorption, oxidation and assimilation with ultimate aerobic destruction of biological solids requires different oxygen fractions. The net use of oxygen is 30 directly related to the proportion of nutrient removal by each mechanism.

BIORATE is a function of the condition of the biomass and the nature of the soluble substrate in contact with the biomass. A single sludge system can be made to exhibit a

- 20 -

maximum biorate and a minimum biorate depending on aeration time and the initial ratio of  $S_0/X_0$ . The active fraction of the biomass influences the range of biorate that its biomass will exhibit.

- 5 Data taken from a 5 series complete-mix, constant volume reactor system is presented to demonstrate typical magnitudes and changes that take place.

TABLE 3

Biorate and Associated Parameters

10

15

20

$S_0/X_0$	MCRT	Biorate I
mg	mg $^{-1}$	mg $O_2\text{gvsshr}^{-1}$
4.0	1	147
1.0	2	90
0.5	3	66
0.25	8	56
0.21	15	43
0.21	40	35

For these rates the initial reactor operated with a 70 minute residence time and the total reactor 420 minutes residence time.

TABLE 4

$S_0/X_0$  vs Biorate ( $\text{mg } O_2 \text{ g}^{-1} \text{ VSS h}^{-1}$ )

$S_0/X_0$	0.056	0.062	0.113	0.182	0.197	0.388	0.437	1.00	4.0
Biorate	35.2	33.1	43.1	57.9	56.3	74.4	70.4	90.0	147

Instantaneous oxygen utilisation rate can be typically measured by a bench scale method in which the time concentration measurement of dissolved oxygen depletion of an oxygenated sample of activated sludge removed from the process reactor is measured. This is a simple batch test which requires a sample to be taken from the activated sludge reaction basin, aerated, placed in a mixed reactor into which is placed a dissolved oxygen measuring sensor; ingress of air is prevented. When the dissolved oxygen meter senses oxygen depletion is taking place, measurements of dissolved oxygen versus time are taken.

Respirometry control as it is currently practised in activated sludge processing is complex and indirect. Respiration rates are measured with a meter which typically consists of a closed completely mixed respiration chamber through which activated sludge from the reacting aeration tank is continuously pumped. Dissolved oxygen concentration is periodically measured with an oxygen sensor at the inlet as well as at the outlet of the respiration chamber which can be achieved by altering the flow direction using a system of valves (as one method).

The problem with measuring the oxygen content at the inlet and outlet of the respiration chamber is that the oxygen content within the respiration chamber varies significantly from the oxygen content at the inlet and outlet of the chamber thus giving erroneous measurement.

The aim of this present invention is to provide a wastewater plant treatment and a method of treating wastewater wherein the metabolic activity of the biomass is maintained at a level to ensure a maximum rate of biological removal of nutrients by oxidative and reductive means through the measurement of BIORATE as previously specified within the principal reaction basin through

- 22 -

measurements that occur by the sensing of oxygen concentration response changes at the end of an aeration sequence.

5       The wastewater treatment plant of the present invention comprises a principal reactor means capable of maintaining wastewater in contact with biologically active degrading micro-organisms, a receiving means to receive wastewater into the reactor means, an oxygen transfer means whereby air is introduced into the principal reactor, a control  
10      means for operating the said sequences and necessary equipment, an oxygen detection means to detect the relative changes in dissolved oxygen present in the principal reactor means and a control means to control the amount of oxygen introduced into the principal reactor means so that  
15      the activity of the micro-organisms is not limited by the amount of oxygen present in the principal reactor wherein the oxygen detection is within the principal reactor means.

20      Measured in the biomass according to the present invention there is provided an apparatus or a process using dispersed growth biological cultures for the treatment of wastewater which comprises the following in combination with each other:

25      A means for maintaining a maximum potential BIORATE in an initial designated unaerated reaction zone for the culture through the defined admixture of influent wastewater and biomass from the principal and final designated reaction zone, a means for introducing dissolved oxygen into the specified principal reaction zone(s) for operation under preselected area and pre-programmed aeration sequences, a  
30      means for interrupting the influent wastewater to the initial designated reaction zone, a means for removing a fraction of the supernatant clear treated wastewater after a set sequence of non-aeration, a means for detecting and measuring the position of the biosludge interface layer, a

- 23 -

means for interacting the biosolids interface with the biosludge wasting program with the detection of the biosludge interface position, a means for setting automatic time sequences for automatic operations, a means for  
5 operation of the principal final designated reaction volume as a variable volume complete-mix unit, a means for measuring the biorate in the principal final designated reaction volume using a dissolved oxygen sensor properly placed in that basin volume, a means for measuring the rate of change of dissolved oxygen concentration and making  
10 comparison with the actual respiration rate to control the rate of introduction of dissolved oxygen into the treatment system, a means of operation for maximising the ratio of potential oxygen utilisation rate (determined through  
15 defined admixture of influent and biomass from the principal reactor) to oxygen utilisation rate in the principal reactor, a means for automatically setting the duration of the aeration sequence as measured and calculated by the actual respiration rate, a means for  
20 optimising the use of aeration power to effect nitrification and denitrification, a means of operating the system through BIORATE control to effect maximum biological phosphorus removal, a means for operating the process so that the principal final designated aeration volume  
25 operates at an approximate biological steady state actual respiration rate (corrected for active fraction of biomass), a means for using the dissolved oxygen depletion rate that results from interrupting the air flow to the basin and a biomass concentration settling algorithm to provide the BIORATE parameter, a means for removing near surface supernatant liquor at from about 20cm below the liquid surface at a constant rate to equivalent liquid depths up to two metres in a preferred 5-6 metre basin depth wherein the reactor configurations permit end basin  
30 or across basin centre feed location, and the reactor configurations permit transverse or longitudinal location of effluent decanting devices, whereby the apparatus and  
35

- 24 -

process is used to treat wastewater.

The wastewater treatment plant may consist of one or more reactors and a minimum of one principal reactor. In a preferred embodiment, the wastewater treatment plant 5 consists of at least two reactors in fluid communication means. In one embodiment the plant consists of several reactors in fluid communication wherein different components such as nitrogen, phosphorus, carbon and the like are together accumulatively removed in different 10 reactors. In a further embodiment the oxygen content in each reactor is significantly different.

In a particularly preferred embodiment the wastewater treatment plant comprises at least two reactors, a first reactor with multiple zones, typically unaerated whereby absorption and biological phosphorus release mechanisms take place, a second reactor which operates through cyclical oxic - anoxic - anaerobic conditions for the microbial degradation of carbon compounds and TKN compounds in a wastewater and for the microbial removal of NO<sub>3</sub>-N, NO<sub>2</sub>-N and the microbial removal of P in the wastewaters; both 20 reactors are in fluid communication.

In a further embodiment the waste treatment plant comprises one principal reactor and the conditions within the reactor are adjusted cyclically so that the conditions vary from aerobic to anoxic to anaerobic and are repeated using 25 definitions described previously.

The oxygen detection means may be any suitable means for detecting dissolved oxygen. Preferably the oxygen detection means detects dissolved oxygen. More preferably, 30 the oxygen detection means is an electronic oxygen sensor able to measure the rate of change of dissolved oxygen concentration as a 4 - 20 milliamp primary control signal through the use of a computer and other programmable logic

- 25 -

controller through which output signals are generated which allow interactive control of the rate of introduction of air into the reactor according to a set concentration profile. More preferably the oxygen concentration is 5 sensed as a result of aeration of the wastewater/microbial mix in the principal reactor.

The oxygen concentration is typically adjusted during water treatment. Preferably the concentration of oxygen in the wastewater/microbial mix is adjusted during an aeration sequence. In particular, the concentration of oxygen present is controlled by adjusting the duration of the aeration sequence and/or adjusting the flow of air in the aeration sequence. The flow of air may be controlled by a speed control mechanism on the generator of the air supply 10 flow or in the flow of air through a position control mechanism of a suitable control valve or other means that are specific to the oxygen input device. Control of the air flow by either means results in the control of the mass 15 rate of transfer of dissolved oxygen to the principal reactor. 20

The oxygen sensor is preferably located within the principal reactor itself. The oxygen sensor is located within the wastewater/microbial mix. More preferably the oxygen sensor is located around 30cm away from any surface 25 of the principal reactor floor. Alternatively, the sensor can be located in a pipe through which biomass from the principal reactor is pumped.

In one embodiment of the present invention the oxygen sensor calculates the actual in basin oxygen uptake based 30 on the sum of the endogenous or basic oxygen uptake and the oxygen uptake rate for oxidation of readily biodegradable substrates, such as substrates in the carbon and nitrogen form, depending upon the micro-organisms that are present and the operating sludge age of the system taking into

- 26 -

account altitude and temperature.

Experimental work has shown a relationship to exist between the ratio of potential oxygen utilisation rate and sludge settleability, provided dissolved oxygen concentration is not limiting. A further relationship exists relative to the value of actual oxygen utilisation rate and the rate of depletion of oxidation reduction potential. The value of actual oxygen utilisation rate, over and above the endogenous oxygen utilisation rate also relates to a quantification of the mass of stored readily degradable soluble substrate remaining in the biomass and the capability of that biomass to participate in quantitative enhanced biological phosphorus removal mechanisms. An embodiment of the invention is to provide means of maintaining a mass transfer of oxygen (through aeration) which approximately equates to the biomass oxygen demand and by such means cause the aerobic degradation mechanisms to take place at an optimal use of oxygen transfer energy. Automatic means are provided for setting the length of the aeration sequence, the mass of micro-organisms to be carried in the principal reactor, setting the desirable dissolved oxygen concentration profile in accordance with the resultant set-point oxygen utilisation rate measured at the end of the aeration sequence and the magnitude of the POUR/OUR ratio.

That the embodiment of the invention is such as to cause co-current nitrification - denitrification to essentially practical completion and to provide for biologically enhanced phosphorus removal mechanisms that are well known to those experienced in the art.

In one embodiment there is one or more reactors the first receives an in fluid communication one of which is admixture of wastewater and micro-organisms contained in the mixed liquor from the last reactor.

- 27 -

In a preferred embodiment the invention relates to the use of a fed-batch reactor volume which is essentially operated as a completely mixed reactor during an aerated sequence, albeit of variable volume, during which time a combined 5 flow of influent domestic wastewater and a flow of mixed liquor solids from the fed-batch reactor volume is introduced.

Even more preferably, a wastewater/microbial mix goes through a complete aeration cycle. The same mix then 10 undergoes a non-aeration cycle, during which time a solids layer and an upper supernatant layer segregate. The sequence of events are completed through the removal of a fraction of the upper supernatant layer from the principal reactor using decanting means. The whole cycle is then 15 repeated.

Control and measurement of the respirometric capacity of the biomass directly in the principal reactor is made possible through the complete-mix air-on and air-off operation that takes place in the preferred variable volume 20 activated sludge treatment methodology. It is also possible to check the progress of treatment in an aerated reaction sequence through interruption of the air flow and subsequent measurement of the dissolved oxygen depletion rate.

25 Measurement of the end of sequence oxygen utilisation rate, combined with the comparison of received process volume (versus minimum set-point volumes) provides the basis for automatic in sequence aeration cycle adjustment which effectively increases the organic loading and hence oxygen 30 utilisation rate as an assurance for biological phosphorus uptake, following its release during otherwise unfavourable uptake reaction conditions.

State-of-the-art on line respirometry as typically applied

- 28 -

- measures dissolved oxygen concentration in the outlet of a respirometer chamber separate from the principal activated sludge reactor, which is equal to the dissolved oxygen concentration in the respiration chamber and should not be rate limiting. If necessary the activated sludge should be aerated before it enters the respiration chamber. The respiration rate is typically measured every minute from the mass balance of dissolved oxygen over the separate respiration chamber. The actual respiration rate is defined as the oxygen uptake rate in the principal aeration tank. To measure this rate, activated sludge from the principal aerated reactor is continuously pumped into the on line separate respiration chamber which is equal to the mean actual respiration rate in the principal activated sludge reactor basin provided that the sludge loading in the respiration chamber equals the loading in the aeration tank. To maintain loading equivalence influent is continuously added to the sludge flowing into the respiration chamber in the proportion.
- 20       $Q_{sam} = Q_{in} V_{res}/V_{at}$   
         $Q_{sam}$  = influent sample flow to respiration chamber.  
         $Q_{in}$  = influent flow  
         $V_{res}$  = volume respiration chamber  
         $V_{at}$  = volume aeration tank
- 25      In all cases on-line respirometry is measured in a scaled down version of the organic loading conditions that exist in the main aerated reactor of an activated sludge plant. A number of simple respiration rates are so identified, the endogenous respiration rate which is typically defined as the oxygen uptake rate of activate sludge that has been aerated for 1.5 hours without feeding. The maximum respiration rate is defined as the oxygen uptake rate of activated sludge with an excess of soluble substrate (readily biodegradable matter). This rate is measured when an excess of influent is continuously introduced to the
- 30
- 35

- 29 -

5 sludge flowing into the respiration chamber. The instantaneous respiration rate is defined as the oxygen uptake rate of activated sludge flowing directly from the completely mixed aeration tank through the respiration chamber. The rate is typically lower than the oxygen uptake rate in the aeration tank the actual respiration rate. The absolute value of the instantaneous respiration rate depends on the detention time in the respiration chamber. The maximum respiration rate of a biomass is also 10 equivalent to its potential oxygen utilisation rate.

15 The embodiment of the present invention uses actual respirometric rate control from measurements taken within the aeration reactor (the principal reactor), not from an inline separate detection unit as is the current general practice.

20 The actual respiration rate in the preferred embodiment of the invention is the sum of the endogenous or basic respiration and the uptake rate for oxidation of readily biodegradable substrate, both carbon and nitrogen forms, the latter only occurring if a nitrifying biomass is selectively grown. At maximum respiration rate the activated sludge will be in an overloaded condition and will result in incomplete removal of readily biodegradable substrate. This means there is a critical respiration rate 25 in between maximum and basic respiration rate and at this rate the effluent quality meets the requirements and the removal of readily biodegradable substrate, among other parameters is satisfactory. At no time should the oxygenation capacity be rate limiting. It is necessary that the kinetic processes that utilise dissolved oxygen be complete to within the reaction time that is provided for the completion of those reactions. In the case of nitrifying mechanisms, the transferred oxygen required by the oxygen demand must be satisfied by the oxygen supply - 30 35 time relationship indicated and provided by the respiratory

- 30 -

- measurement. It is necessary to initially determine by manual means, loading rates, actual respiration rates and dissolved oxygen concentration. There is an advantage when the actual respiration rate is always equal to or near to the critical actual respiration rate. In this case the activated sludge is never overloaded and works at a maximum acceptable rate. Therefore the total amount of activated sludge maintained in the system is optimal and the metabolic activity of the biomass can be maintained at acceptable values to assist with other nutrient removal reactions. An ideal constant actual respiration rate can always be met through manipulation of biomass concentration, aeration time, and rate of supply of oxygen demand.
- 15 To those experienced in the art, there are a number of ways of operating dispersed growth wastewater treatment systems. These generally include the operation of one or more connected reactors, at constant volume at least one of which is aerated continuously, through which the admixture of wastewater and micro-organisms flow. The final basin in these systems is a "quiescent" non-aerated vessel in which solids liquid separation takes place, the clear overflow supernatant being the treated effluent and the underflow solids which are directed to waste and to the reactant vessels. Various internal recycle flows also occur. While the invention can be embodied in this configuration, it is not so limited in its application. In its preferred embodiment the invention relates to the use of a fed-batch reactor volume which is essentially operated as a completely mixed reactor during an aerated sequence, albeit of variable volume, during which time a combined flow of influent wastewater and a flow of mixed liquor solids from that reactor is introduced.
- 30 This invention, in its preferred embodiment is specific to reaction conditions that are generated and not necessarily

- 31 -

- to numbers and zones of the reactor volumes through which the said reactants pass. This is not a limitation on the embodiment. Principally the volume fraction as described as the fed-batch reactor undergoes complete mix aeration,
- 5       during a specific aeration cycle, for which variable volume complete mix kinetics can be ascribed to that specific volume. Following the specific non-aeration sequence, during which time a solids layer and an upper supernatant layer segregate, the relative depths being dependent upon
- 10      the contact flow history of influent wastewater and the mixed liquor solids concentration of a stream of solids, which is directed from the principal variable - volume completely mixed volume to the influent stream of wastewater for admixture. This embodiment of operation
- 15      requires a means of removing a specified fraction of the supernatant upper layer during the continued non-aeration sequence. When this event is completed, the aerated sequence is continued with further admixture of reactants as prescribed previously.
- 20      While not limiting the embodiment of the invention, the mode of operation of fed-batch reactor treatment methodology is most easily conducted in more than one basin module. Cycles of aeration operation can be easily set for 2 hours and other two basin multiples. Other cycles of
- 25      operation can be set for 3 basins, and other additions, for either even or odd basin operation. The embodiment of the invention while not limited to the basin modules, is easily explained as a two basin operation. Those experienced in the art will be able to extrapolate from the two basin operation used in this discussion.
- 30      Whilst upstream reaction volumes have an important bearing on the efficiency of the treatment methodology, the principle requirement is that there is a major volume fraction of the fed-batch reactor volume, in excess of 50%,
- 35      that undergoes variable volume complete mix reaction

- 32 -

conditions, using a specific device for combined aeration and mixing.

While it is preferable that a system of diffused aeration is used, this does not necessarily limit the application of  
5 the invention. Two set-ups for the invention will be described. Both configurations require the use of a dissolved oxygen sensor having an acceptable response time for measuring a rate of change of dissolved oxygen concentration ( $do_2/dt$ ).

10 Previous discussion has explained the importance of load demand and load supply of dissolved oxygen, relative to substrate load, load application time and viable fraction of biomass.

15 The first configuration requires the use of a suitable dissolved oxygen sensor, complete with the electronics that are necessary to enable the measurement of the rate of change of dissolved oxygen concentration as a control signal, through the use of a specific computer or other programmable logic controller, through which output signals  
20 are generated, which allow interactive control of the rate of introduction of air into the complete-mix reactor (and/or other fluidly connected reactor volumes), during the aeration sequence. Interactive control is through the duration of the aeration sequence combined with the flow of air through a speed control mechanism on the generation of the air supply or in the flow of air through a position control mechanism of a suitable control valve, as a means of restricting the flow of air. Control of the airflow by either means results in the control of the mass rate of  
25 30 transfer of dissolved oxygen to the complete-mix fed batch reactor.

In the first preferred embodiment the invention requires a minimum of one reactor vessel, preferably operated as a

- 33 -

fed-batch reactor, which operates as a variable volume activated sludge reactor basin. During the process of filling and aeration where more than one vessel compartment is used, these will be in fluid communication.

5 An important feature of the invention is the manner and means by which the wastewater to be treated is introduced into the means for reaction. Also important is the initial mass ratio of activated sludge solids that is caused to come into contact with the influent waste flow. Of further  
10 importance is the time of interaction of these component flows and the means by which intermixing and intermeshing of the two flow streams is maintained. One method employed in the industry utilises either fixed sub surface or floating surface electrically operated propellers which  
15 cause a directional flow to take place and an intermixing of solids and liquid phases through the expenditure of energy. The invention can be used with this means of operation. The preferred embodiment of the invention contains no specially installed equipment of the type  
20 referred to. Mixing in this invention is variously caused through the operation of the means for aeration, which is essential to the aerobic degradation and anoxic degradation processes that are maintained and/or the design of combined flow conditions using conduits, channels and flow  
25 directional baffles.

It has been found that there are benefits in process that derive from the means of introducing the relative proportions of activated sludge solids and wastewater, the time of flow-mixed contact of these two streams and the manner in which kinetic natural mixing is used during the initial contacting reaction period. While not omitting the application of the invention, the combined initial reaction time is designed to ensure a minimum of 65% removal of the readily degradable soluble substrate fraction contained in  
30 a wastewater. This fraction can be variable in  
35

- 34 -

wastewaters. By way of example, for a BOD of around 300 mg/l, and an associated COD of around 600 mg/l, in a domestic wastewater, and for a typical reticulation design, a 25% readily degradable soluble substrate fraction 5 assumption base will give acceptably good process results. A process reaction time of twenty to around sixty minutes hydraulic retention time within the biological selector will normally generate the desired result, provided the compartmentalisation required of the inlet configuration 10 design performs with the correct degree of dispersion together with an appropriate mixing energy that enhances biological floc nucleation and aggregation. The relative placement of overflow and underflow baffles relative to designated bottom water level and the reactor basin floor 15 is a feature of the invention. The open area of the underflow baffle is restricted to generate a high underflow energy which is more than three times greater than the mean flow energy across the overflow weir. The underflow free area uses a fraction of the available length of the 20 underflow baffle. Thus high mixing energy regimes are generated near to the reactor basin floor sections which are followed by reduced energy fluctuation - aggregation zones at the upper zone, formed by the overflow baffles. The inlet configuration geometry is designed to promote 25 pulsed energy zones which ensure floc transport and floc growth, together with the biological reactions of soluble BOD removal and conversion to intracellular storage products, partial denitrification and phosphorus release by the biological phosphorus sequestering micro-organisms that 30 are caused to grow in the biomass.

While all of the processes referred to above take place in a single vessel embodiment, a preferred embodiment utilises a four (4) basin facility or a four (4) module facility. Each module can comprise one (1) to N (where N ≥ 1) basin 35 combinations. The factoring on 4 modules is dependent on the set (design) four (4) hour cycle upon which the basin

- 35 -

geometry is designed. To those experienced in the art it is obvious that other factoring numbers such as 3 and 5 can equally be used. Such design satisfies specific requirements for load (hydraulic) division, organic load manipulation, biological treatment (including concurrent nitrification-denitrification and biological phosphorus removal) provision of oxygen demand by automatic biorate control, maximisation of oxygen transfer efficiency, optimisation of solids-liquid separation relative to the decant depth and decant removal rate of treated effluent.

The four module preferred embodiment operates in every way as a net continuous process, with acceptance of influent on an as received basis with a continuous discharge of effluent from the plant, the flow rate being an hourly constant rate relative to the actual decant volume that is removed from each module. A different protocol can be run whereby the discharge rate is constant at each decant sequence. The preferred embodiment is configured for a flow split operation followed by the four module (basin) processing. A module can be configured with influent at one end of the module (basin) and effluent decanting at the opposite end or with effluent decanting at the remote end of the module (basin) but located on the long basin walls (see Figures 6(a) to 6(g)). Typically a domestic wastewater containing 300 mg/l TSS, 55 mg/l TKN which is to be treated to a flow range of 6 x ADWF will require an inlet configuration zone of up to 8% of the total vessel area. This zone is divided into a minimum of 5 and typically between 8 and 14 sub zones for each principal reactor each having a volume fraction that initially generates an oxygen uptake rate in the first mixed zone of in excess of 20mg O<sub>2</sub>/gVSS/hr. The volume fraction of mixed liquor suspended solids from the main reactor volume will typically be in excess of 20% and less than 33% of average influent flow. Under overflow baffle arrangement terminates on either side of the reactor basin such that half of the combined flow discharges to a position on

- 36 -

either side of the principal reactor basin.

Pumped mixed liquor suspended solids continues throughout the duration of the complete cycle. Influent wastewater is interrupted during the settle sequence. Waste sludge is  
5 collected from zone subsequent to the inlet configured biological selector, and removed during an aeration sequence or during the non-aeration settle sequence. Reactor basin dimensioning is typically based on up to 15kg MLSS/m<sup>2</sup> of reactor area; and for efficient nutrient removal  
10 in domestic wastewater, a BOD load of 0.33-0.40 kg BOD/m<sup>3</sup> at a fractional decant volume of 0.46. Decant liquid depth removal is up to 38mm/min. without the addition of phosphorus precipitant. With the addition of phosphorus precipitant, for normal dry weather treatment operation  
15 this depth rate can be increased to 44mm/min. Basin solids flux load is up to 15kg MLSS/m<sup>2</sup> and up to 10kg TKN/kg MLSS/m<sup>2</sup>/d, within 20% for the former and within 30% for the latter.

20 A further development of the system incorporates attached growth media to enhance the volumetric biomass load that can be accommodated in the system. For this embodiment the variable volume reactor basin is divided into three zones.

25 The first is the biological selector zone which is sized for domestic wastewater generally as per the above description. For organic industrial wastewaters this fraction is increased to occupy approximately 12% of the basin surface area. The zone is compartmentalised as described to effect successive removal of soluble substrate. The first zone is followed by a second zone in fluid communication. The return flow of mixed liquor solids from zone 3 to zone 1 for applications where the influent BOD is up to 2000 mg/l or zone 2 to zone 1 increases to two to three times the average influent flow. The caged random pack media is contained in a flow through  
30

- 37 -

cage. Zones 1 through 3 are in continuous fluid communication. Random packing in zone 2 is approximately 0.4 metres from the reactor basin floor and to within 0.15 metres below designated bottom water level. Zone 2 is 5 fitted with means for varying aeration intensity, zone 1 has aeration diffusers connected to valves which allow coarse aeration/mixing control.

It will be obvious to those experienced in the art that the same mode of operation and control applies to the treatment 10 of wastewaters for carbon removal only, for carbon and nitrogen removal, for carbon and phosphorus removal and for carbon and nitrogen and phosphorus removal.

The described arrangement has been advanced by explanation and many modifications may be made without departing from 15 the spirit and scope of the invention which includes every novel feature and novel combination of features hereindisclosed.

Those skilled in the art will appreciate that the invention described herein is susceptible to variations and 20 modifications other than those specifically described. It is understood that the invention includes all such variations and modifications which fall within the spirit and scope.

**CLAIMS:**

1. A method of treating waste by controlling metabolic activity of micro-organisms of a biomass containing the waste so as to remove selected components of the waste prior to disposal of treated waste, characterised in that the method comprises monitoring at least one oxygen utilisation rate of the biomass in order to determine a requisite amount of oxygen to be supplied to the biomass and monitoring a period of aeration of the biomass by the oxygen so as to maintain a predetermined oxygen utilisation rate or value to achieve removal of the components.  
5
2. A method according to claim 1, characterised in that the waste is wastewater, typically domestic, industrial, commercial or the like waste, including human wastes, body washing wastewater, clothes washing wastewater and food preparation wastewater, including fractional components of such wastes.  
15
3. A method according to claim 1 or 2, characterised in that the biomass is activated sludge.
- 20 4. A method according to any preceding claim, characterised in that the process takes place in one or more reactors, such as a basin, vessel or the like.
5. A method according to any preceding claim, characterised in that the reactor or reactors are a variable volume activate sludge reactor or reactors.  
25
6. A method according to any preceding claim, characterised in that there is a minimum of two reaction vessels or reactors in fluid communication with each other.
7. A method according to any preceding claim,

- 39 -

characterised in that the last reaction vessel or reactor is the principal reactor and is more than 50 percent of the total reaction volume.

8. A method according to any preceding claim,  
5 characterised in that the method operates with sequenced air-on and air-off time periods.

9. A method according to any preceding claim,  
characterised in that the method removes up to 40 percent  
10 of the reactor volume as segregated supernatant liquid  
during the air-off sequence without entrainment of settled  
solids from within a settled sludge layer in the reactor.

10. A method according to any preceding claim,  
characterised in that the principal reactor is fitted with  
15 diffused aeration grids located at or towards the floor or  
base of the reactor or reactors.

11. A method according to any preceding claim,  
characterised in that the reactor is provided with at least  
two air supply downcomers and motor operated control  
valves.

20 12. A method according to any preceding claim,  
characterised in that the motor operated control valves are  
alternately closed and opened according to a set program of  
air-on operation.

25 13. A method according to any preceding claim,  
characterised in that all motor operated control valves are  
operated in unison during the set program of air-on  
operation.

30 14. A method according to any preceding claim,  
characterised in that a flow of liquid-solid suspension  
from the principal reactor is recycled to the reactor by

- 40 -

being pump transferred to a first reactor for admixture with influent wastewaters prior to or simultaneous with admission to the reactor.

15. A method according to any preceding claim,  
5 characterised in that the admixture of influent and  
principal reactor liquid-solid suspension flows into the  
principal reactor.

16. A method according to any preceding claim,  
10 characterised in that the net fluid oxidation reduction  
potential of the liquid stream passing to the principal  
reactor is between -150 mV and -200 mV as compared to a  
hydrogen reference electrode.

17. A method according to any preceding claim,  
15 characterised in that up to 40 percent of the reactor  
volume is introduced into the admixture reactor during the  
set air-on sequencing period.

18. A method according to any preceding claim,  
20 characterised in that the fraction of principal reactor  
contents admixed with the influent wastewater is sufficient  
to yield the -150 mV to -200 mV oxidation reduction  
potential in a time of less than 80 minutes.

19. A method according to any preceding claim,  
25 characterised in that part of the contents of the principal  
reactor are pump transferred to a first reactor without  
admixture with influent wastewaters.

20. A method according to any preceding claim,  
characterised in that the contents of the initial reactor  
flow towards the principal reactor.

21. A method according to any preceding claim,  
30 characterised in that the oxidation reduction potential of

- 41 -

the segregated sludge in the principal reactor falls substantially in the range of -150 mV to -200 mV within 90 minutes into the air-off sequence.

22. A method according to any preceding claim,  
5 characterised in that the biological activated sludge solids concentration of 60 percent of the reactor volume is about 5000 mg/L.

23. A method according to any preceding claim,  
characterised in that the biomass is intermittently aerated  
10 and decanted.

24. A method according to any preceding claim,  
characterised in that the rate of removal of biologically degradable materials is maximised.

25. A method according to any preceding claim,  
15 characterised in that the biomass is of constant volume and is continuously aerated.

26. A method according to any preceding claim,  
characterised in that the reactor or reactors are formed as slope walled lagoon structure reactors having earthen,  
20 concrete stabilised, membrane lined or concrete retaining walls or a concrete walled vessel or a structural steel vessel.

27. A method according to any preceding claim,  
characterised in that the biomass remains in motion for up  
25 to 10 minutes after interruption of the supply of air or oxygen.

28. A method according to any preceding claim,  
characterised in that the values of dissolved oxygen concentration are automatically in situ sensed and  
30 monitored at intervals of 10 to 20 seconds upon cessation

- 42 -

of air-on sequence.

29. A method according to any preceding claim,  
characterised in that the dissolved oxygen sensor measures  
the in-situ biomass oxygen utilisation rate for use in  
5 automatically controlling and regulating the input of  
oxygen from an air input device, such as a pump or  
compressor.

10 30. A method according to any preceding claim,  
characterised in that while the supply of air is on the  
supply is continuous and occurs while influent wastewater  
is introduced into the reactor or reactors.

31. A method according to any preceding claim,  
characterised in that the cycle of operation is about 4  
hours with the aeration sequence being about 2 hours.

15 32. A method according to any preceding claim,  
characterised in that the rate of depletion of dissolved  
oxygen during the initial period after cessation of  
aeration is automatically measured and calculated.

20 33. A method according to any preceding claim,  
characterised in that automatic controls, mathematical  
algorithms and primary sensors, including those that  
measure liquid level, liquid temperature, settled-sludge  
interface level, dissolved oxygen concentration, oxidation  
25 reduction potential, ammonia nitrogen, nitrate nitrogen,  
soluble phosphorus, time, in combination or in part, are  
used to operate the process.

34. A method according to any preceding claim,  
characterised in that one section of the principal reactor  
is aerated at the start of the aeration sequence.

30 35. A method according to any preceding claim,

- 43 -

characterised in that the biomass from the one section of the principal reactor is used to determine the rate of change of oxygen increase at the commencement of the aeration sequence.

5       36.       A method according to any preceding claim, characterised in that several reactors are in fluid communication with each other.

10      37.       A method according to any preceding claim, characterised in that at least one of the reactors has multiple zones.

15      38.       A method according to any preceding claim, characterised in that the oxygen detection means is an electronic oxygen sensor able to measure the rate of change of dissolved oxygen concentration as a 4-20 milliamp primary control signal.

39.       A method according to any preceding claim, characterised in that the oxygen concentration is adjusted during waste treatment, during the aeration sequence or the like.

20      40.       A method according to any preceding claim, characterised in that the concentration of oxygen present is automatically controlled by adjusting the duration of the aeration sequence and/or adjusting the flow of air in the aeration sequence.

25      41.       A method according to any preceding claim, characterised in that the oxygen sensor is located within the principal reactor, preferably about 30 cm from the surface of the principal reactor floor, or in a full-flow conduit or pipe through which part of the liquid/solid 30 material from the principal reactor flows, typically to the influent admission reactor.

- 44 -

42. A method according to any preceding claim, characterised in that the TKN loading on the activated sludge is up to about 0.01 kg TKN/kgMLSS/m<sup>2</sup>/d for typical domestic sewage applications.
- 5 43. A method according to any preceding claim, characterised in that the total P loading of activated sludge solids is up to about 0.002 kg Phosphorus/kgMLSS/m<sup>2</sup>/d for typical domestic sewage applications.
- 10 44. A method according to any preceding claim, characterised in that the aerial loading of solids concentration is up to about 20 kg MLSS/metre<sup>2</sup> of reactor area.
- 15 45. A method according to any preceding claim, characterised in that the dissolved oxygen concentration in the principal reactor is controlled to less than 0.7 mg/L (average) for 75 percent of the air-on time and to between 2 and 3 mg/L for the remaining air-on time period.
- 20 46. A method according to any preceding claim, characterised in that the daily oxygen supply is controlled to at least meet the stoichiometric oxygen requirements for removing the oxygen demanding contaminants or components from the wastewater to be treated.
- 25 47. A method according to any preceding claim, characterised in that it further comprises:  
microbially treating the wastewater in the activated sludge process in the presence of a micro-organism population acclimated to the wastewater contaminants and their concentrations in the wastewater and including  
nitrifying micro-organisms capable of converting ammonia nitrogen to at least nitrite nitrogen and

- 45 -

facultative micro-organisms capable of denitrifying nitrite and optionally nitrifying organisms capable of converting nitrite to nitrate nitrogen and

5 facultative micro-organisms capable of reducing nitrate to nitrite nitrogen to nitrogen gas and phosphorus removal micro-organisms capable of biologically removing available soluble phosphorus.

48. A method according to any preceding claim, characterised in that the mixed liquor solids concentration 10 in the principal reactor is sensed and recorded at the moment that the air supply to that reactor is terminated and the oxygen uptake rate is sensed, recovered and analysed following termination of the process oxygen supply and the liquid level at the time of closure of the influent 15 valve to the reactor (plus two minutes).

49. A method according to any preceding claim, characterised in that the sensed process values are processed and used to determine:

20 the waste sludge pumping time,  
the duration of the air-on sequence for the next cycle,

the mass flow rate of air for the next cycle,  
adjustment of the dissolved oxygen concentration set-points,

25 such that the process conditions are sufficient to maintain the set-point oxygen uptake rate in the principal reactor determined at the end of the previous aeration sequence.

50. A method according to any preceding claim, 30 characterised in that the dissolved oxygen concentration in the primary reactor is maintained at sufficiently low concentrations to assist the nitrogen removal process to take place via the nitrite mechanism.

- 46 -

51. A method according to any preceding claim, characterised in that sufficient mixing is provided through the oxygen transfer equipment, selectively or in total.

5 52. A method according to any preceding claim, characterised in that nitrogen nutrients and/or phosphorus nutrients are introduced to the influent wastewaters.

53. A method according to any preceding claim, characterised in that pH correction is made to the influent wastewaters.

10 54. A method according to any preceding claim, characterised in that phosphorus sequestering chemicals are added to the principal reactor.

15 55. A method according to any preceding claim, characterised in that phosphorus and/or nitrogen nutrients are introduced to the influent wastewaters.

56. A method according to any preceding claim, characterised in that phosphorus and nitrogen nutrients and pH correction is made to the influent wastewaters.

20 57. A method according to any preceding claim, characterised in that the first reactor is divided into any number of volumes, such as two, three, four, five or more volumes.

25 58. A method according to any preceding claim, characterised in that the mixing energy associated with the flow path near to the floor of the first reactor basin is a minimum of three times the mixing energy associated with the flow path near to the liquid surface of the first reactor causing localised energy pulsation on the admixture.

- 47 -

59. A method according to any preceding claim,  
characterised in that the potential oxygen uptake rate of  
the biomass in the principal reactor as measured using an  
80 percent/20 percent biosolids/influent mixture averages  
5 at three times the oxygen uptake rate of the biomass as  
sensed and calculated by the in-basin dissolved oxygen  
instrumentation on a daily basis.
- 10 60. A method according to any preceding claim,  
characterised in that there are multiple units, each unit  
consisting of the minimum two reaction vessels in fluid  
communication.
- 15 61. A method according to any preceding claim,  
characterised in that the biomass includes attached growth  
media, fixed or mobile in one of the two reaction vessels.
62. A method according to any preceding claim,  
characterised in that the wastewaters contain high  
concentrations of sulphate and/or sulphide.
- 20 63. A method according to any preceding claim,  
characterised in that the dissolved oxygen in the principal  
reactor is controlled to less than 3 mg/L.
64. A method according to any preceding claim,  
characterised in that the set-point oxygen uptake rate is  
experimentally determined and typically is in the envelope  
of  $10 \pm 2 \text{ mgO}_2/\text{gVSS/day}$ .
- 25 65. A method according to any preceding claim,  
characterised in that the components to be removed from the  
waste are nitrogen, carbon or biological phosphorus or  
combinations thereof including derivatives thereof and  
materials containing them.
- 30 66. A method according to any preceding claim,

- 48 -

characterised in that the nitrogen removal is measured as TKN, NH<sub>3</sub>-N, NO<sub>2</sub>-N, NO<sub>3</sub>-N, the carbon removal is measured as COD, BOD, TOC, and phosphorus removal is measured as PO<sub>4</sub>.

67. A method according to any preceding claim,  
5 characterised in that there are four reactors and a split  
flow input arrangement for distributing influent to each  
reactor.

68. A method according to any preceding claim,  
10 characterised in that the influent inlet is located at one  
end of the reactor and effluent decanting located at the  
opposite end of the reactor, or the influent inlet is  
centrally located with effluent decanting at or towards  
opposite end walls.

69. A method according to any preceding claim,  
15 characterised in that the oxygen uptake rate or measured  
potential oxygen uptake rate in the initial admixture  
reactor is at least 20 mgO<sub>2</sub>/gVSS/hr.

70. An apparatus for treating waste by automatically  
20 controlling metabolic activity of micro-organisms of a  
biomass containing the waste so as to remove selected  
components of the waste prior to disposal of treated waste,  
characterised in that the apparatus comprises a principal  
reactor means capable of maintaining waste in contact with  
25 biologically active degrading micro-organisms, a receiving  
means to receive waste into the reactor means, an oxygen  
transfer means whereby air is introduced into the principal  
reactor, a control means for operating the said sequences  
and means, an oxygen detection means to detect the relative  
changes in dissolved oxygen present in the principal  
30 reactor means and a control means to control the amount of  
oxygen introduced into the principal reactor means so that  
the activity of the micro-organisms is not limited by the  
amount of oxygen present in the principal reactor wherein

- 49 -

the oxygen detection is within the principal reactor means.

71. An apparatus according to claim 70, characterised in that it is useful for carrying out the method of any one of claims 1 to 69.

5 72. A waste treatment plant comprising the apparatus of claim 70 or 71.

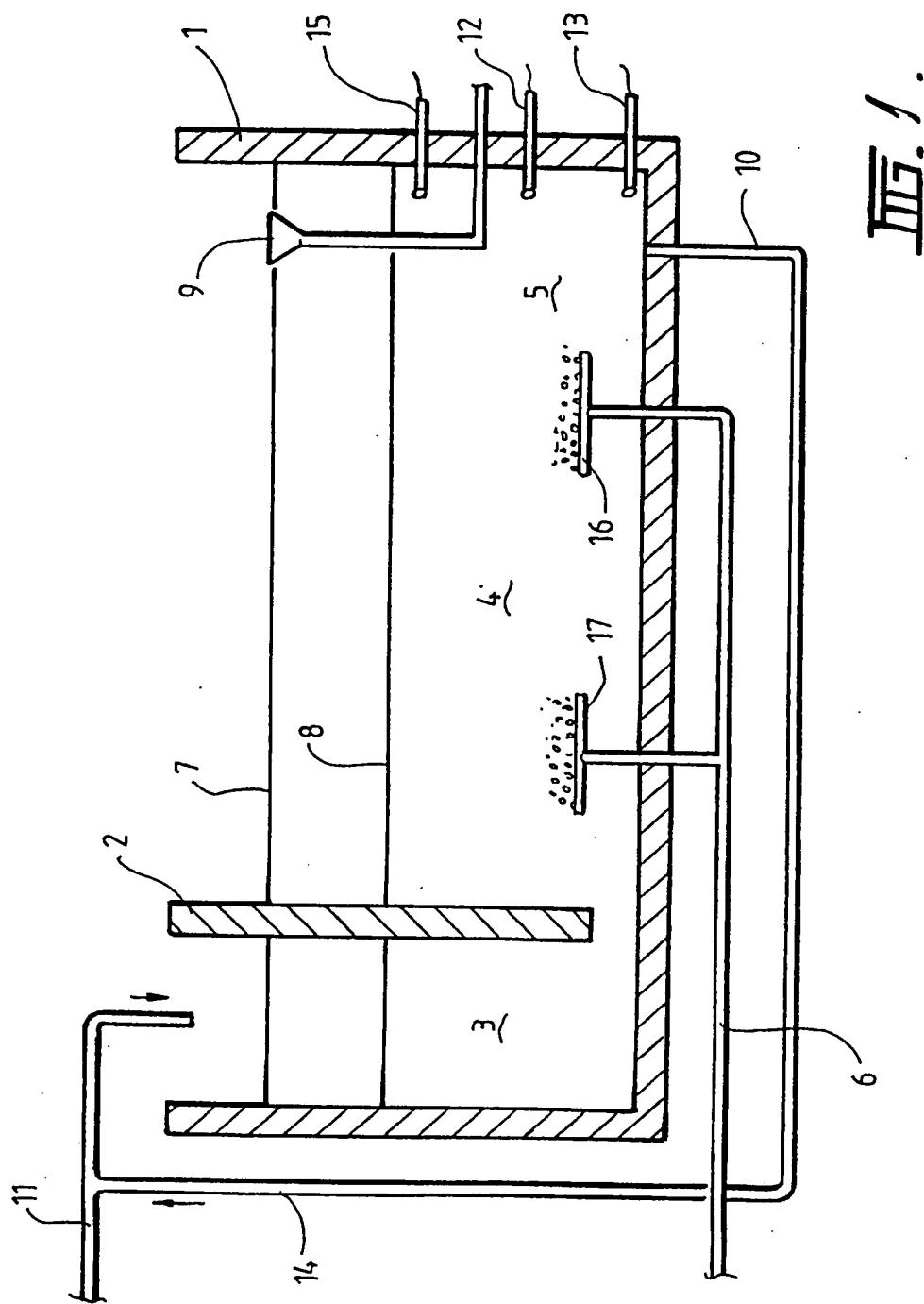
73. A waste treatment plant employing the method of any one of claims 1 to 69.

10 74. A method substantially as hereinbefore described with reference to any one of the accompanying drawings.

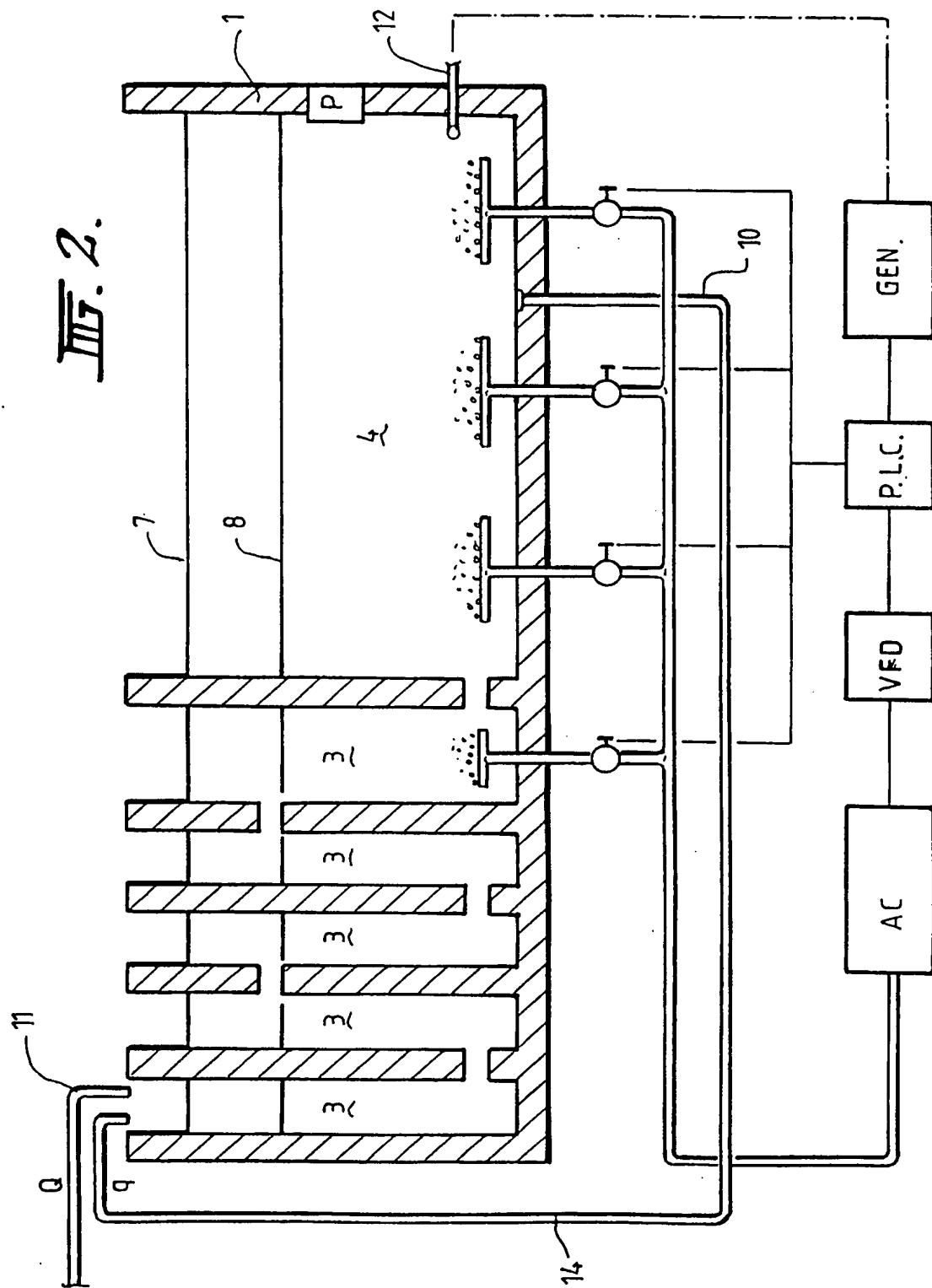
75. An apparatus substantially as hereinbefore described with reference to any one of the accompanying drawings.

15 76. A plant substantially as hereinbefore described with reference to any one of the accompanying drawings.

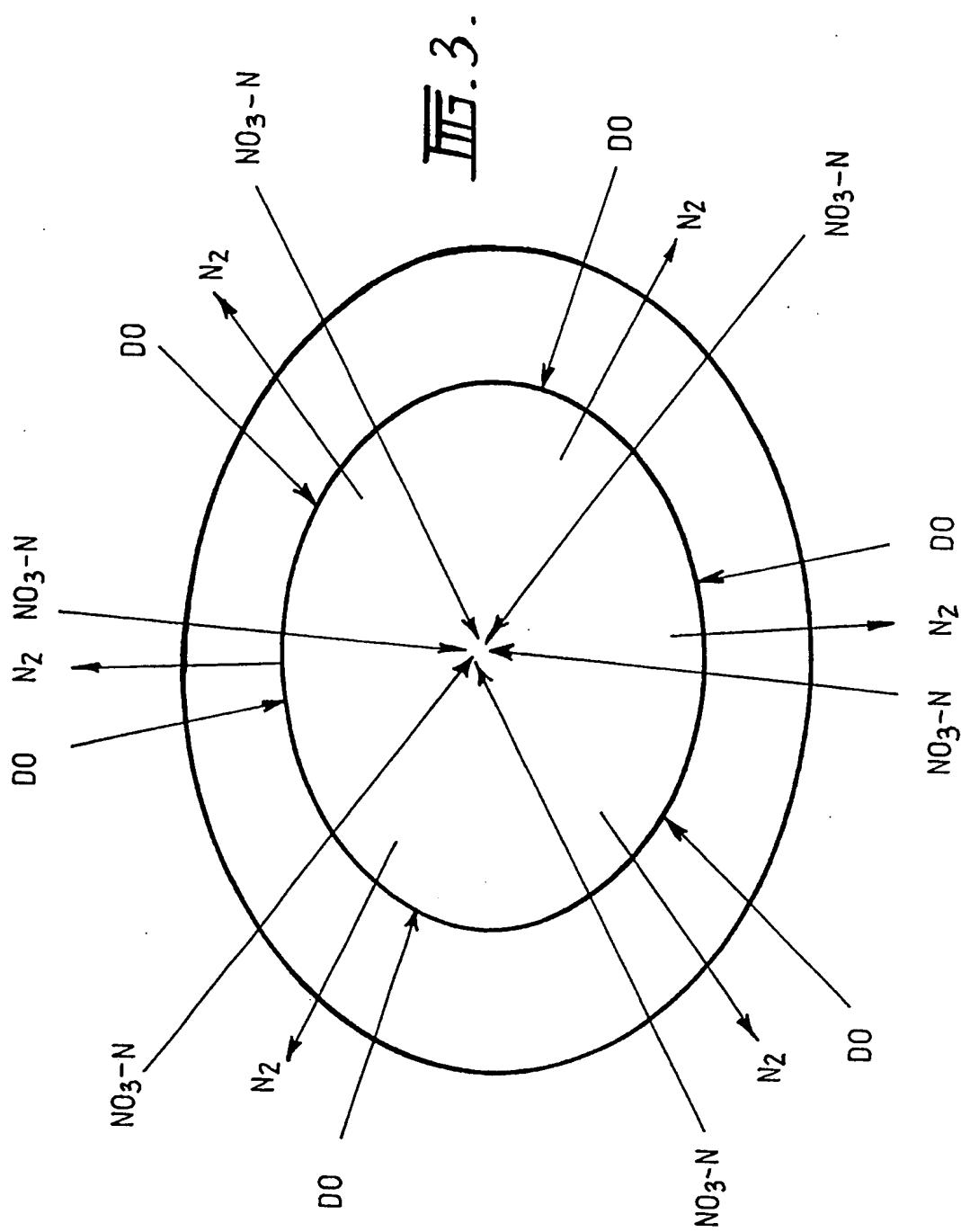
77. A method, apparatus or plant according to any preceding claim having automatic control of one or more steps, elements or features.



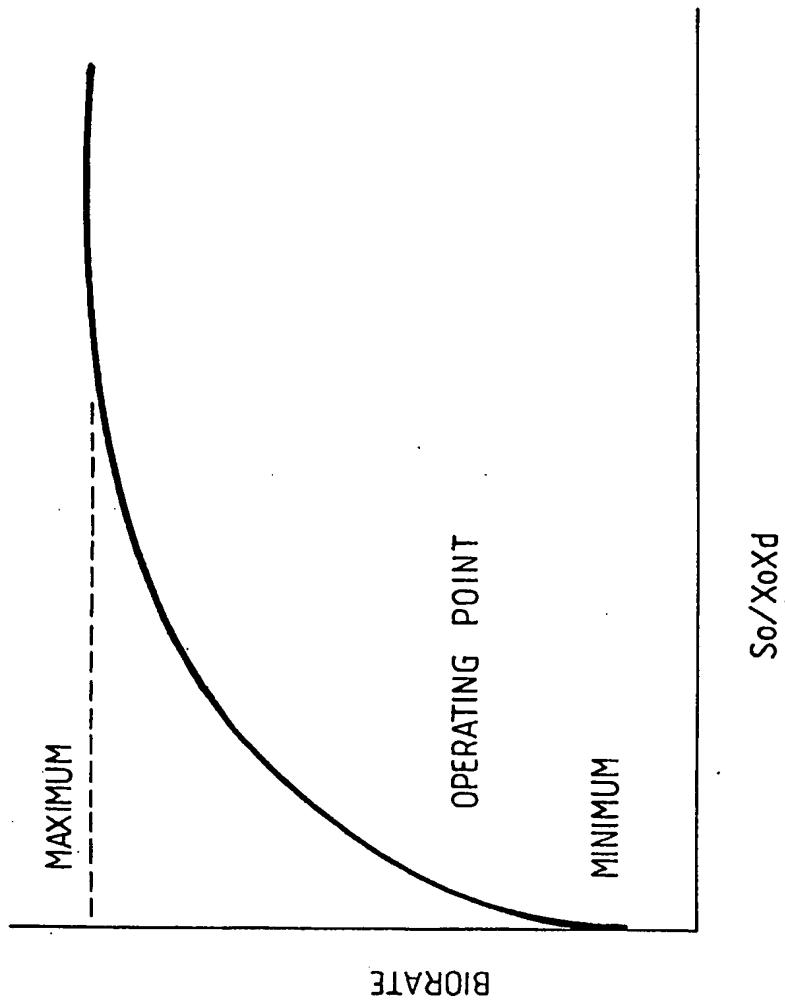
III. 1.



3/7



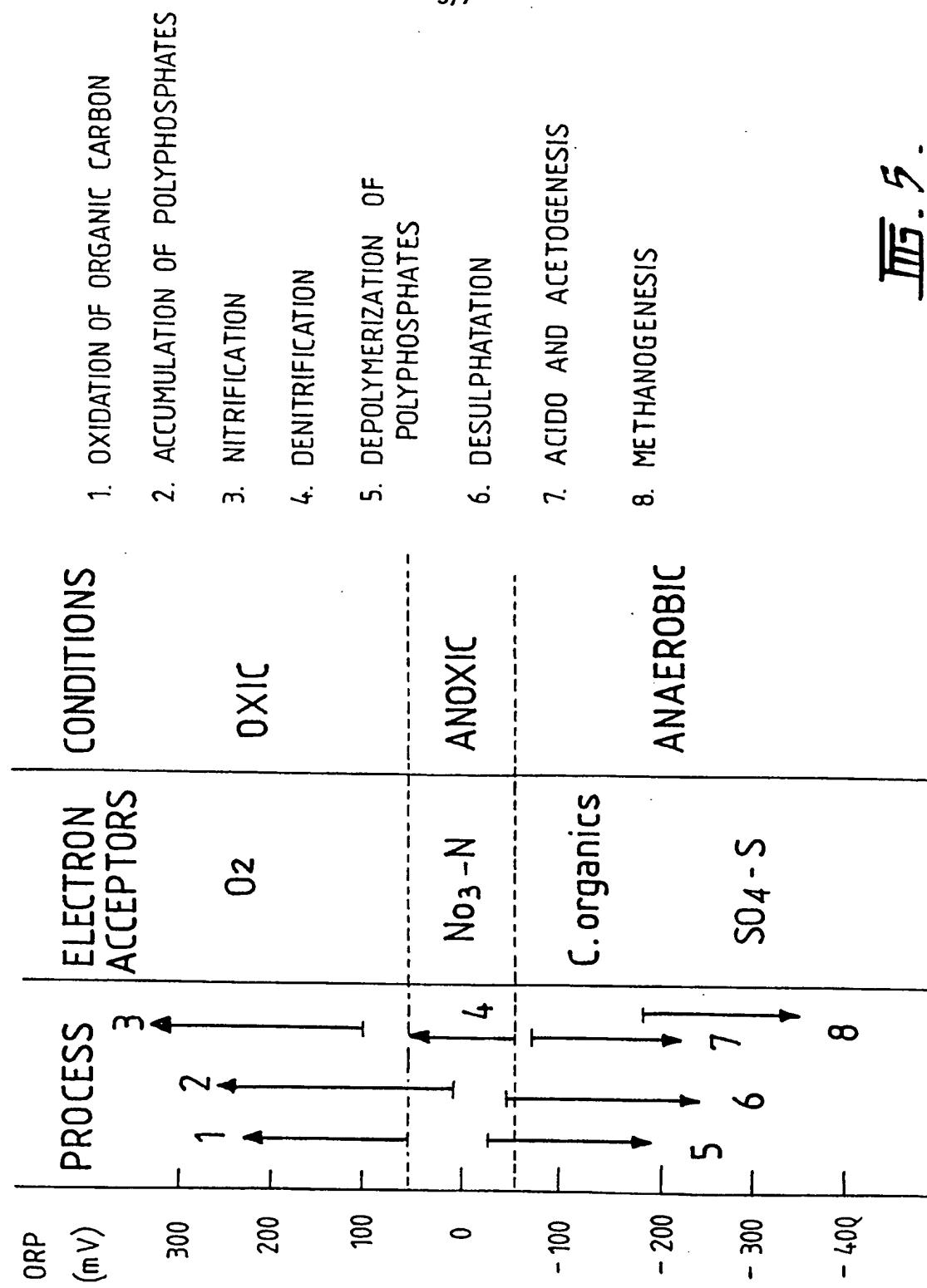
4/7



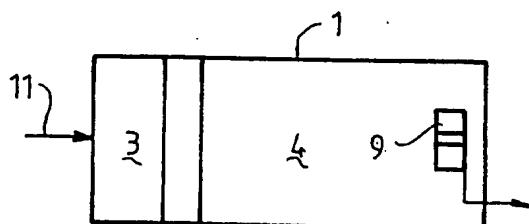
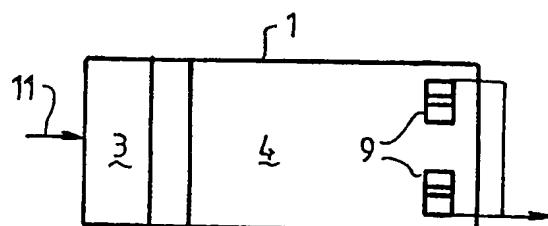
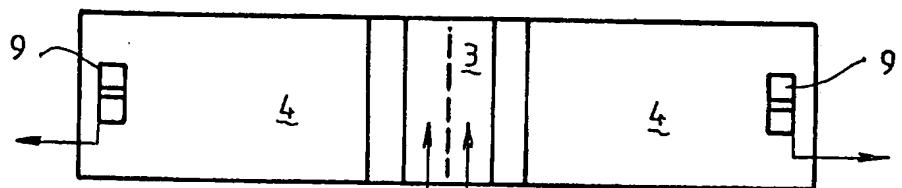
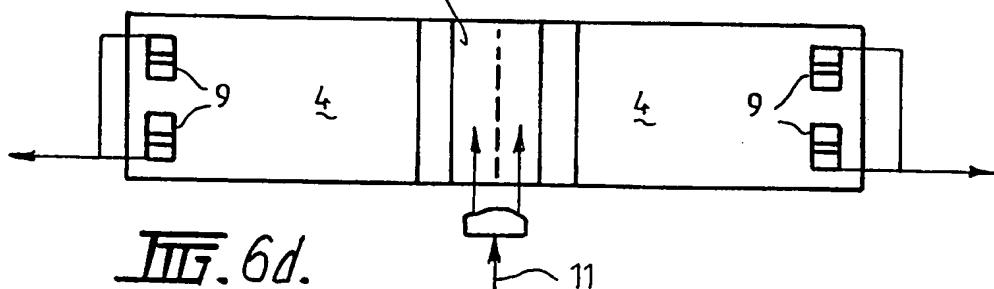
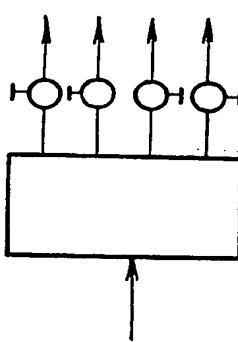
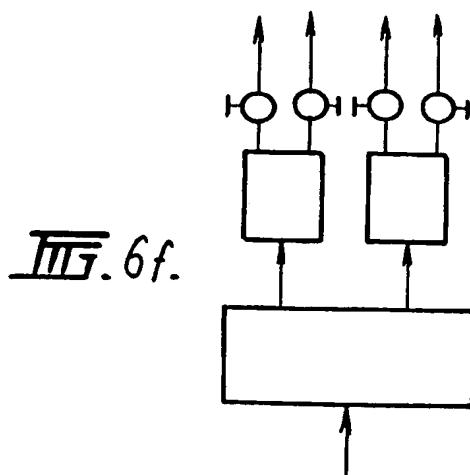
III. 4.

SUBSTITUTE SHEET (RULE 26)

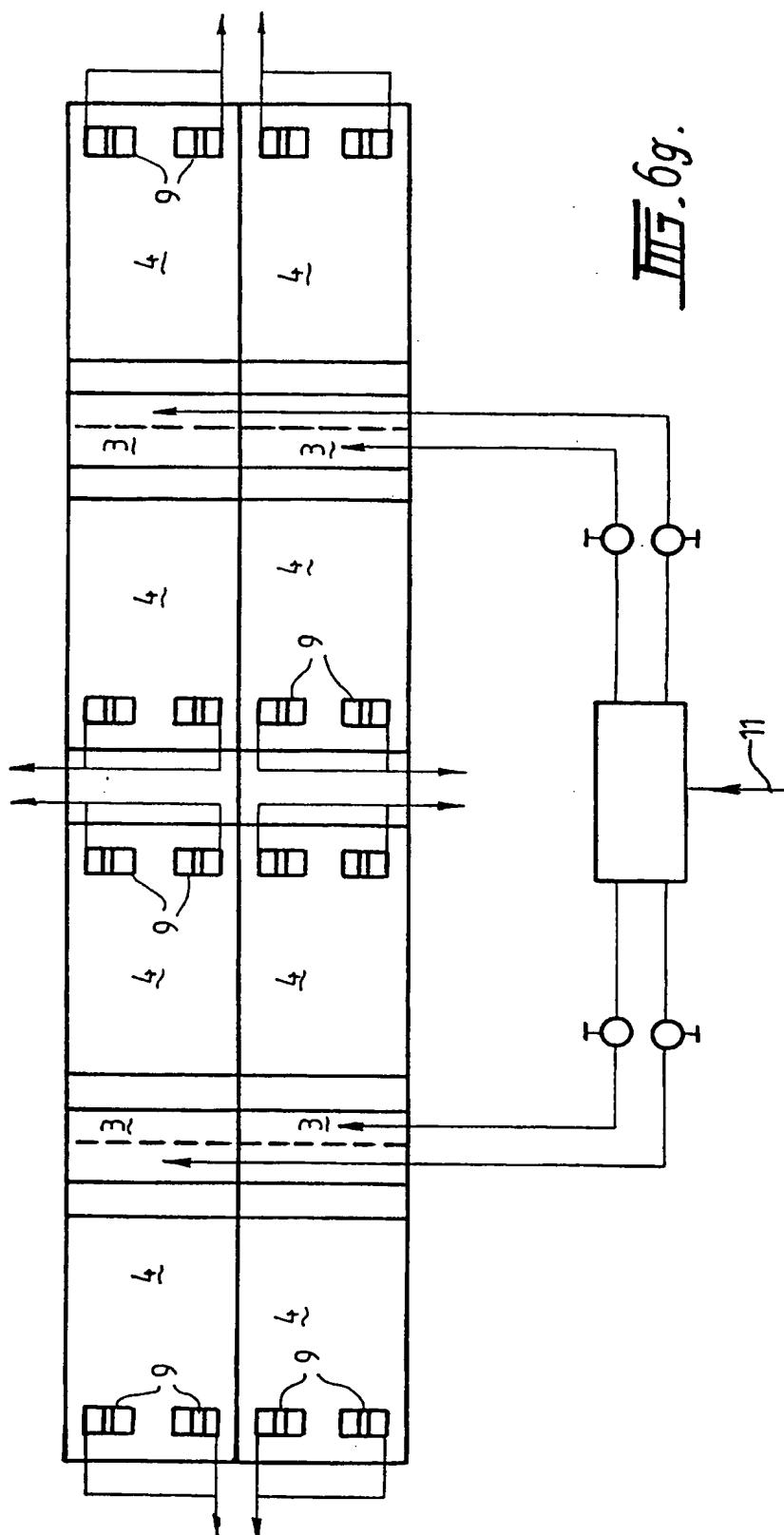
5/7



6/7

FIG. 6a.FIG. 6b.FIG. 6c.FIG. 6d.FIG. 6e.

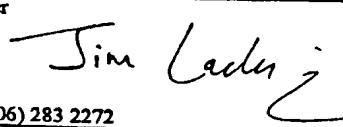
7/7



SUBSTITUTE SHEET (RULE 26)

## INTERNATIONAL SEARCH REPORT

International Application No.  
PCT/AU 96/00379

<b>A. CLASSIFICATION OF SUBJECT MATTER</b>		
Int Cl <sup>6</sup> : C02F 3/12; C02F 3/20; C02F 3/30		
According to International Patent Classification (IPC) or to both national classification and IPC		
<b>B. FIELDS SEARCHED</b>		
Minimum documentation searched (classification system followed by classification symbols) IPC C02F 3/12; C02F 3/20; C02F 3/30; C02C 1/06		
Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched AU: IPC as above		
Electronic data base consulted during the international search (name of data base and, where practicable, search terms used) DERWENT: (OXYGEN:) AND (CONTROL: OR REGULAT: OR ADJUST: OR MAINTAIN:) CHEM ABS: AS FOR DERWENT AND ALSO (ACTIVATED () SLUDGE) AND (MEASUR: OR DETECT: OR MONITOR: OR DETERMIN: OR ESTIMAT: OR SENS: OR CALCULAT: OR ANALYS:)		
<b>C. DOCUMENTS CONSIDERED TO BE RELEVANT</b>		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	Patent Abstracts of Japan, C-96, page 11, JP 56-161892 A (HIROSHI KISHI) 12 December 1981 Abstract	1-58,60-77
X	Patent Abstracts of Japan, M-82, page 108, JP 54-120952 A (TOKYO SHIBAURA DENKI K K) 19 September 1979 Abstract	1-58,60-77
X	Patent Abstracts of Japan, C-169, page 20, JP 58-43290 A (HITACHI PLANT KENSETSU K K) 12 March 1983 Abstract	1-58,60-77
<input checked="" type="checkbox"/> Further documents are listed in the continuation of Box C		<input checked="" type="checkbox"/> See patent family annex
<ul style="list-style-type: none"> <li>* Special categories of cited documents:</li> <li>"A" document defining the general state of the art which is not considered to be of particular relevance</li> <li>"E" earlier document but published on or after the international filing date</li> <li>"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</li> <li>"O" document referring to an oral disclosure, use, exhibition or other means</li> <li>"P" document published prior to the international filing date but later than the priority date claimed</li> </ul> <p>"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</p> <p>"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone</p> <p>"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art</p> <p>"&amp;" document member of the same patent family</p>		
Date of the actual completion of the international search 28 October 1996	Date of mailing of the international search report 6 Nov 1996	
Name and mailing address of the ISA/AU AUSTRALIAN INDUSTRIAL PROPERTY ORGANISATION PO BOX 200 WODEN ACT 2606 AUSTRALIA Facsimile No.: (06) 285 3929	Authorized officer  JIM LACKIE Telephone No.: (06) 283 2272	

## INTERNATIONAL SEARCH REPORT

International Application No.  
PCT/AU 96/00379

C (Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	Patent Abstracts of Japan, C-138, page 89, JP 57-144089 A (HITACHI PLANT KENSETSU KK) 6 September 1982 Abstract	1-58,60-77
X	Patent Abstracts of Japan, C-620, page 142, JP 1-104395 A (HITACHI PLANT ENG & CONSTR CO LTD) 21 April 1989 Abstract	1-58,60-77
X	Derwent Abstract Accession No. 92-164348/20, Class D15, JP 04-104896 A (UNITIKA LTD) 7 April 1992 Abstract	1-58,60-77
X	Derwent Abstract Accession No. 86-002061/01, Class D15, HU TO35-614 A (KELETMAGYARORSZAGI) 29 July 1985 Abstract	1-58,60-77
X	Derwent Abstract Accession No. 80-43581C/25, Class D15, DT 2852546 A (MENZEL & CO GmbH) 12 June 1980 Abstract	1-58,60-77
X	AT 335382 A (SIEMENS A G) 10 March 1977 Page 2, lines 18-44, Figure 1, Claims 1-6	1-58,60-77
X	DE 2838621 A (SEKOULOV et al.) 13 March 1980 Whole document	1-77
X	EP 69353 A (MENZEL GmbH & CO) 12 January 1983 Whole document	1-77
X	US 4818408 A (HAMAMOTO) 4 April 1989 Whole document	1-77
P,X	EP 683139 A (BFI ENTSORGUNGSTECHNOLOGIE GmbH) 22 November 1995 Whole document	1-58,60-77
X	US 3994802 A (CASEY et al.) 30 November 1976 Claims 1-29, Tables 1, 2	1-27,29-31,33-47,49-77
X	GB 1263753 A (OMNIUM D'ASSAINISSEMENT) 16 February 1972 Whole document	1-27,29-31,33-47,49-77
X	US 4159243 A (OKEY) 26 June 1979 Whole document	1-27,29-31,33-47,49-58,60-77
X	US 3342727 A (BRINGLE) 19 September 1967 Whole document	1-27,29-31,33-47,49-58,60-77

**INTERNATIONAL SEARCH REPORT****Information on patent family members**International Application No.  
PCT/AU 96/00379

This Annex lists the known "A" publication level patent family members relating to the patent documents cited in the above-mentioned international search report. The Australian Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

Patent Document Cited in Search Report				Patent Family Member			
DE	2838621	AT	169	EP	8725		
EP	69353	DE	3126412	DK	1076/83	EP	82868
		JP	58501022	WO	8300143		
US	4818408	AU	78184/87	CA	1323710	DE	3780384
		DK	4667/87	EP	260187	JP	63069595
		NO	873753				
EP	683139	DE	4417259				
US	3994802	BE	840694	CA	1066438	DE	2616212
		ES	447056	FR	2307768	GB	1531534
		IT	1058129	JP	51128157	SE	7603963
		ZA	7601916				
GB	1263753	AT	296903	BE	727525	CA	934486
		CH	557877	DE	1906588	ES	363489
		FR	1567182	NL	6902261		
US	4159243	AU	38494/78	CA	1099830	JP	54048958
END OF ANNEX							